



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3219-1
Job Sheet 179353



Part No: D3219-1

Job Qty: 50 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		6/29/18	0.00	0.00	Start Up Waterjet		21 18/06/21
100	Waterjet	50 pcs		6/29/18	0.01	1.04	Waterjet1		21 18/06/21
120	QC	50 pcs		6/29/18	0.00	0.00	QC8		38
150	Packaging	50 pcs		6/29/18	0.00	0.00	Packaging3		21 18/06/21
160	QC21-SA	50 Ea		6/29/18	0.00	0.00	QC21		21 18/06/21

Part Op 100 - 1-Cut as per Dwg D3219

Descriptions: 150 - *** STOCK IN STEP CELL ***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	4.8200 sf (.0964 ea)	90-Start up Operation	FM 137980 FM 138346 SO 18009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	5	93	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plate	0.316inches + 0.006 - 0.001	0.322 0.315		
2	Plate	2.293inches ± 0.005	2.298 2.288		
3	Plate	0.375inches ± 0.010	0.385 0.365		
4	Plate	0.125inches ± 0.010	0.135 0.115		
5	Plate	0.125inches ± 0.010	0.135 0.115		

Plex 6/18/18 10:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐		Skid-tube ☐	
NCR No. _____		Scrap ☐		Machining ☐	
Date: _____		Use-as-is ☐		Thermoforming ☐	
Description Work		Suspected Unapproved ☐		Large Fab ☐	
				Cross tube ☐	
				Small Fab ☐	
				Finishing ☐	
				Composite ☐	
				Water Jet ☐	
				Prod. Eng. Coord. ☐	
				Rec/Store/Packaging ☐	
				Supplier ☐	
				Engineering ☐	
				Quality ☐	
				Other ☐	
				MRB (QSI042) Approval ☐	
				Completed By _____	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause		Container No: S083126		Part: D3219-1		Job No: 179353		Serial No/Batch: S083126		Revision:		Inspector:		Exp Date:		Instructions:		Date: 06/21/18					
Environment		Design		Doc/Data		Equip/Tooling		Handling/Pre		Material		Internal Transport		Tribal Knowledge		LOA		Substation		Past Expiry Date		Misidentified	
☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐	
No Re-verification		Operator		Offset/Setup		Supplier		Training		Use for Testing		Poor Information		Rushing		Product Improvement		Process Improvement		Manufacturing Process		Past Due	
☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐	
Cracks		Crimp/Kink/Ripple/Wave		Cuffs		Crushing		Heat Treat		Wave/Twist in Tube		Marks/Chatter		Inspection Incomplete/Unqualified		Contamination		Countersink		Cut Too Short		Instructions Incomplete/Unclear	
☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐	
Wrong Stock Pulled		Out of Sequence		Off-set		Mislabeled		Fit/Function		Misaligned/off center		Positioned Wrong		Outside Dimensions		Over/Under tolerance		Part Incorrect		Part Lost/Missing		Part Moved	
☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐	
Drawing		Finish		Misread		Turning Sequence		QC / QA Coordinator Approval		Lead hand / Supervisor Approval Verification		Completed By		MRB (QSI042) Approval		Engineering Quality Other		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Thermoforming Large Fab		Skid-tube Machining	
☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐		☐	